

Split

Work Order ID 79307-1

79307

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January-24-12 1:57:08 PM

Item ID: D3212-1 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Floor Window
 Start Date: 24/01/2012 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 07/02/2012 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: M.C.J. Date: 12/01/24 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	FLOW WATER JET	0.00							
100	Waterjet	0.00							
FLOW CNC Waterjet	Memo								
	1-Cut blankas per Dwg D3212 Dwg Rev: C Prog Rev: C								
	2-Deburr if necessary								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
110	HAAS I	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA349 and Dwg D3212								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120	QC	0.00							
Quality Control	Memo								

SCRAP

B2-2-10

(10)

B2-2-10

SL 12/03/18

SL 12/03/18

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O: 79307

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3212-1 PAR #: _____ Fault Category: Small FAB / water Jet NCR: Yes No DQA: Not Date: 12/05/14
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 12/5/14

NCR: 17-1405

WORK ORDER NON-CONFORMANCE (NCR) 31.13

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
21/5/12	# B MO	Scratches found in window Durain Assembly R.C Process	S 17/5/12	Scrap + Destroy QM + 1 unable to remove	12-05-02 FF	S 17/5/12	S 12/05/12	S 12/5/12

NOTE: Date & initial all entries

Work Order ID 79307

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Item ID: D3212-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Floor Window
 Start Date: 24/01/2012 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 07/02/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>ST210</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

[Handwritten signature]

pos-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 79307

79307

Parent Item: D3212-1

D3212-1

Parent Item Name: Floor Window

Start Date: 24/01/2012

Required Date: 07/02/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev: A New Issue 05-11-09 JLM
 IPP Rev: B Water jet/ ccn798 06-05-08 EC
 IPP rev.C back on haas 07.04.09 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2728-1		Manufactured	No			100	Each	0.0000	0	0			
D2728-1									**				
Dart Logo label													
MACRLICS.125		Purchased	No			140	sf	225.2634	0.9745	8.206316			
MACRI ICS 125									**				
1/8" Polycast II Sheet													

Location

Loc Qty

Loc Code

MAT019

225.2634

110633

8

117324

0.2467

117431

10.7967

119591

206.22

119591

10

B12-2-10

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 79307
Description: Floor Window		Part Number: D3212-1
Inspection Dwg: D3212	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.734	+/-0.005	12.734	✓		H-G	
6.367	+/-0.005	6.367	✓		"	
0.625	+/-0.005	0.625	✓		Vern	2-3
Ø0.156	+0.005/-0.001	0.157	✓		Vern	2-3
R0.25	+/-0.030	0.25	✓		R-G	
8.150	+/-0.005	8.150	✓		H-G	
3.750	+/-0.005	3.750	✓		"	
0.313	+/-0.010	0.313	✓		"	
15.14	+/-0.030	15.142	✓		"	
12.520	+/-0.005	12.520	✓		"	
6.260	+/-0.005	6.260	✓		"	
1.312	+/-0.005	1.312	✓			
0.313	+/-0.010	0.313	✓			
3.750	+/-0.005	3.750	✓			
8.150	+/-0.005	8.150	✓			
8.462	+/-0.005	8.463	✓			
9.09	+/-0.030	9.09	✓			

Measured by: SL	Audited by: mcl	Prototype Approval:	N/A
Date: 12/03/18	Date: 12/03/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	
B	07.05.28	Dimensions updated per Dwg Rev. B	KJ/JLM	

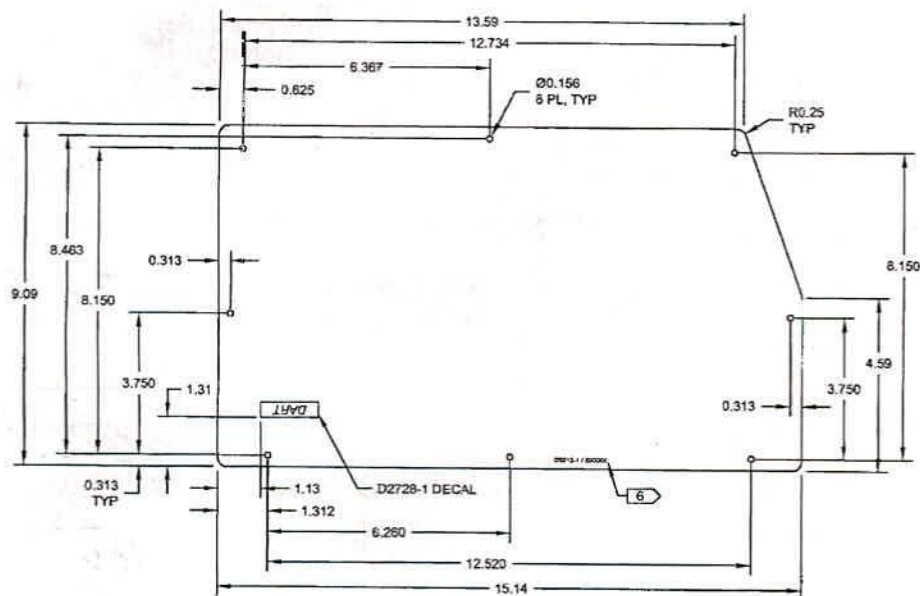
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

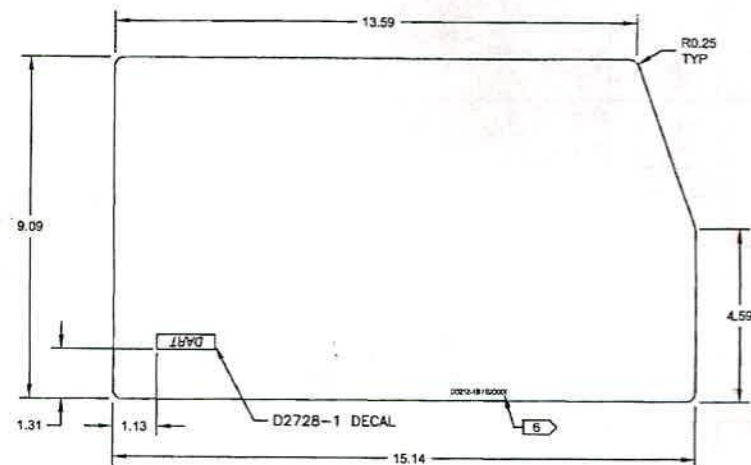
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NOTE: Date & initial all entries



D3212-1 FLOOR WINDOW



D3212-1B BLANK FLOOR WINDOW

RELEASED
2011-06-16
MP

NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK REF. DART SPEC. M-ACRYLIC-S.125
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3212-X" AND B/N "BXXXXX" PER QSI 044 6.4 WITHIN 0.50 FROM EDGE
- 7) WEIGHT: 0.72 lbs
- 8) CHECK DIMENSIONS WITH TEMPLATE D3212-1T1

UNCONTROLLED
SUBJECT TO AMENDMENT
NOTICE

N: 79307 M.L.J
12/01/24

C	UPDATE TO CURRENT STD; ADD D3212-1B. REASON: PAR11-109.	MB	11.06.03
B	UPDATE MATERIAL PER NCR 029	SSH	06.04.13
A	NEW ISSUE	CP	03.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.06.03		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3212
TITLE FLOOR WINDOW
REV. C
SHEET 1 OF 1
SCALE NIS

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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